

Work Order ID 52435

September 23, 2009 2:48:18 PM



Page 1

Item ID: PB67-43001-63 *IG* Accept

Revision ID: *B/C per CCN 09-678.*

Item Name: Handle Assembly



Setup Start



Stop



Start Date: 09/25/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: *MF* Date: *09-09-23* Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001	<i>Rev B1 C</i>
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100		0.00
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Large Fab

Large Fab

Memo

0.00

Large Fab

1- chamfer both ends (0.090") on -129 and -127 □2- chamfer (0.090") only the angle end on -157 □3- drill #40 hole in center of -129 before welding -131 caps, to let air out □4- weld -131 to -129 as per dwg □5- grind weld flush □6- assemb

Pl 09 09 29

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
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QC

Memo

0.00

Quality Control

PD 09.09.29

120	QC5- Inspect part completeness to step on W/O	0.00
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QC

Memo

0.00

Quality Control

27 509/01/30

(+2)

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: PB67-43001-63

Accept

Revision ID: B1

Item Name: Handle Assembly

Start Date: 09/25/2009 Start Qty: 2.00

Required Date: 10/02/2009 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat****
START TIME: 9:30 AM OVEN TEMPERATURE: 320°F
FINISH TIME: 10:00 AM

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- assemble by drilling thru both -157 and -133 as per dwg 2- install spring slotted pin as per dwg

Cpl 09 10 06

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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160 QC5- Inspect part completeness to step on W/O

0.00

2) 80106



QC

Memo

0.00

82

✓

Quality Control

170 Identify as per dwg & Stock Location: 444

0.00



Packaging

Memo

0.00

91016

20 SP

Packaging

180 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/10/07

PR 09-10-6

Quality Control

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 52435

Parent Item: PB67-43001-63RevB1

Parent Item Name: Handle Assembly



Start Date: 09/25/2009

Required Date: 10/02/2009



Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
240-107  SPRING SLOTTED PIN		Purchased	No			150	Each	296.0000	2.0000			
											SAD 09-09-28	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	296	
109274	91	
111088	205	

CR3213-4-2  Cherry Rivet	Purchased	No				150	Each	78.0000	2.0000			
											SAD 09-09-28	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	78	
102569	78	

PB67-43001-127RevB1  Handle Arm	Manufactured	No				100	Each	6.0000	2.0000			
											SAD 09-09-28	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
43327	6	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 52435



Parent Item: PB67-43001-63RevB1



Parent Item Name: Handle Assembly

Start Date: 09/25/2009

Required Date: 10/02/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ PB67-43001-129RevB1 Tube Handle		Manufactured	No			100	Each	7.0000	2.0000			
											SAD 09-09-28	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7

45002

7

PB67-43001-131RevB1

Manufactured No



Tube End Cap

100

Each

18.0000

4.0000



SAD 09-09-28

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

18

45770

18

PB67-43001-133RevB1

Manufactured No



Clevis

150

Each

8.0000

2.0000



SAD 09-09-28

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

8

45001

8

2

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Shop Packet Print

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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PB67-43001-137RevB1		Manufactured	No			100	Each	5.0000	2.0000			
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✓ Locking Sleeve



SAD 09-09-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

44999

5

100

Each

5.0000

2.0000

2

✓ PB67-43001-157RevB1

Manufactured No



Tube



SAD 09-09-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

43390

5

2

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Shop Packet Print

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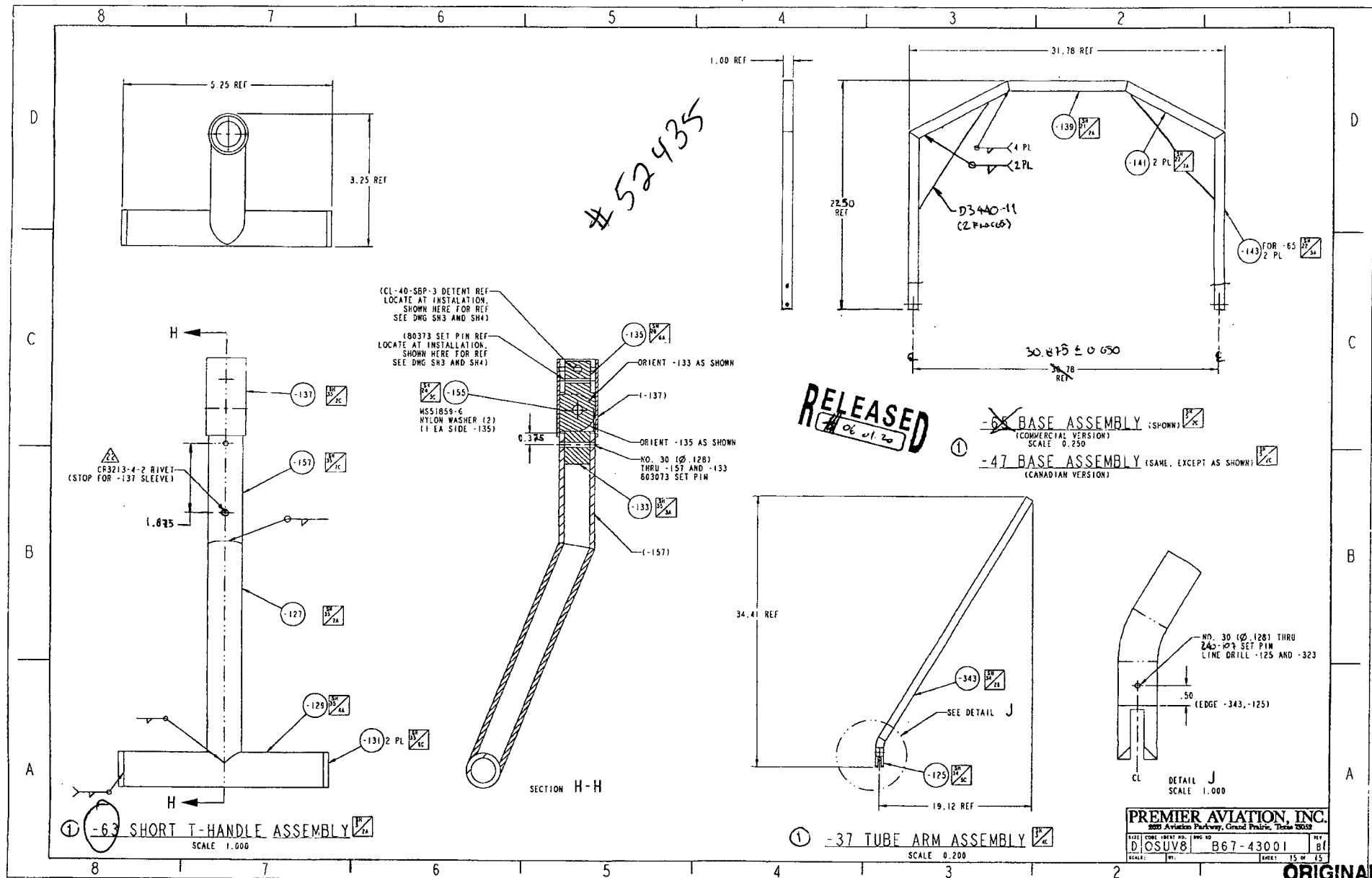
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